

20-7881

014031



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2362-3**Job Sheet 205560****Part No:** D2362-3**Job Qty:** 35 pcs**Part Name:** Step Support Bracket**Part Weight:** 0 lbs**Job Created:** 1/14/20**Due Date:** 1/20/20**Type:** SOLD**Status:** New**Priority:** Medium**Job Tracking No:****Created By:** Marie Lajeunesse**Description:**

Note: D2362 REV.F IPP: G 00.05.18 Added inspection level 8 EC IPP REV:H 2020.01.13 AS PER DWG REV.F DD
VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	HAAS 4 Axis	35 pcs	1/20/20		1.00	8.79	HAAS - 1			20-01-16
							HAAS - 2			
							HAAS - 3			
							HAAS - 4			
110	QC 2	35 pcs	1/20/20		0.00	0.00	QC 2 - 1			20-01-16
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			

ART

AEROSPACE

Order No: S248133

2362-3

205560

No/Batch: S248133

REV.F

Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hewitsonbury, ON K84 1K7

CANADA

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2025

01/16/20

PUSH!!!



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Container No: S248133**Part:** D2362-3**Job No:** 205560**Serial No/Batch:** S248133**Revision:** REV.F**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 01/18/20

RUSH!!!

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120 QC 8	35 pcs	1/20/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	mk 20/01/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	35 pcs	1/20/20	0.00 4.38	Small Fab - 1 - B4B	DAS JAN 17 2020
				Small Fab - 2 - B4B	58
				Small Fab - 3 - B4B	8-09 JAN 20 2020
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 Powdercoat - 1 White G(A)- B4B	35 pcs	1/20/20	0.00 1.28	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20. 01-20.
				Powdercoat - 4 - B4B	
150 QC 3	35 pcs	1/20/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
160 Small Fab - 3 - B4B	35 pcs	1/20/20	0.00 4.38			Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
						Small Fab - 9 - B4B	
						Small Fab - Various 1 - B4B	
170 QC 5	35 pcs	1/20/20	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
180 Packaging 3-1 - Stock - B4B	35 pcs	1/20/20	0.00 0.00			Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	

DAS
81
9-89
2020 1 2 2020

JAN 22 2020

DAS
81
9-89

JAN 22 2020

DAS
28
9-89

DAS
82
9-89

34 pcs
1/10 23 Janv.
2020

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	JAN 23 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	
190 QC 21 - SA	35 pcs	1/20/20	0.00 0.00		

Part Op 100 - (HAAS CNC vertical machine #1) 1- Mill as per Folio FA800 Rev: 14 & Dwg D2362 Rev: F 2-Deburr per Descriptions: dwg D2362

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Small Fab) Deburr

140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:50 FINISH TIME: 3:20

150 - (QC3- Inspect Part Finish)

160 - (Small Fab) Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362

Batch

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2265	Step Bracket	35 pcs (1 ea)	100-HAAS 4 Axis	5010411-S194317-S247166
D2397-1	Rubber Cushion	35 pcs (1 ea)	160-Small Fab - 3 - B4B	20x S 269252-7x S 190235
D2397-3	Rubber Cushion	35 pcs (1 ea)	160-Small Fab - 3 - B4B	28x S 269276-7x S 190250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D2265	35	48	0
160-Small Fab - 3 - B4B	D2397-1	35	7	0
	D2397-3	35	7	0

Part Specifications

Specifications could not be found.

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Entered: 2RDate: Feb 10/2020
20-01-16

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-7881Route update only ☐

Job: <u>205560</u> Part No. <u>D2362-3</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>20-01-16</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>		MRB (QSI042) <u>PD 20-01-16</u>																													
Description Work Order Deviation				Disposition																															
Engraving is no good due to programming issues				Scrap Program fix <u>20-01-16</u>																															
								Completed By <u>DAS 20 9-89 20-01-16</u>																											
								Lead hand / Supervisor <u>DA 20-01-16</u>																											
QC / QA Coordinator <u>PD 20-01-16</u>																																			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☒ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☒ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																																	